

Date: Tuesday, 3/27/2007 10:10:12 AM
 User: Eric Charbonneau

Process Sheet

| | | | | | |
|-----------------------|---------------------------------------|--|------------------|----------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : GUIDE ASSEMBLY | |
| Job Number | : 31462 | | | | |
| Estimate Number | : 12709 | | | | |
| P.O. Number | : N/A | | Part Number | : D3572041 | |
| This Issue | : 3/27/2007 S.O. No. : N/A | | Drawing Number | : D3572 UNDER REVIEW | |
| Prsh Rev. | : NC | | Project Number | : N/A | |
| First Issue | : 3/26/2007 Type : LARGE FAB ASSY | | Drawing Revision | : U/R | |
| Previous Run | : 30675 | | Material | : N/A | |
| Written By | | | Due Date | : 4/2/2007 Qty: 2 Um: Each | |
| Checked & Approved By | | | | | |
| Comment | : Est Rev:A New Issue 07-02-07 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|---------|-----------------------|---|--|-----------------|
| 1.0 | D35721 | TUBE | | |
| | | Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s) | | N/A |
| | | GUIDE | | |
| | | Batch: <u>B31476</u> | | E 07.03.28 (2) |
| 2.0 | D35727 | CAP | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) | | |
| | | CAP | | |
| | | Batch: <u>B31476</u> | | E 07.03.28 (2) |
| 3.0 | D35725 | BRACKET | | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) | | |
| | | BRACKET | | |
| | | Batch: <u>B31477</u> | | E 07.03.28 (2) |
| 4.0 | MS21059L3 | Nut Plate | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) | | |
| | | Nut Plate | | |
| | | batch: <u>M101588</u> | | FF 07-03-27 (2) |
| 5.0 | MS20426AD33 | Rivet | | |
| | | Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) | | |
| | | Rivet | | |
| | | batch: <u>M7481</u> | | FF 07-03-27 (2) |

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 M6061T6TS0750W062

6061-T6 SQ Tube.75x.062W



Comment: Qty.: 2.3405 f(s)/Unit Total: 2.3405 f(s)

6061-T6 SQ Tube.75x.062W

Batch: M103069

RE 07.03.26

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink and rivet nut plates as per dwg

EC / SB FF

07/03/26 ②

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Tube to 26.75" as per Dwg D3572

RE 07.03.27

2-drill & mill per dwg D3572

RE 07.03.27

2-Weld as per Dwg D3572

A/R AL ROD

Batch: M100234

LG. 07.03.28 2

LG. 07.03.28 2

3-Grind welds for end caps.

9.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL

RE 07.03.28

RE 07.03.28

②

Comment: INSPECT WORK TO CURRENT STEP

10.0 QC9

VISUAL WELDING INSPECTION



ENGINEERING
APPROVAL

RE 07.03.28

RE 07/03/28 ②

②

Comment: VISUAL WELDING INSPECTION

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N/A

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

LE 07.03.29

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.03.29

00064

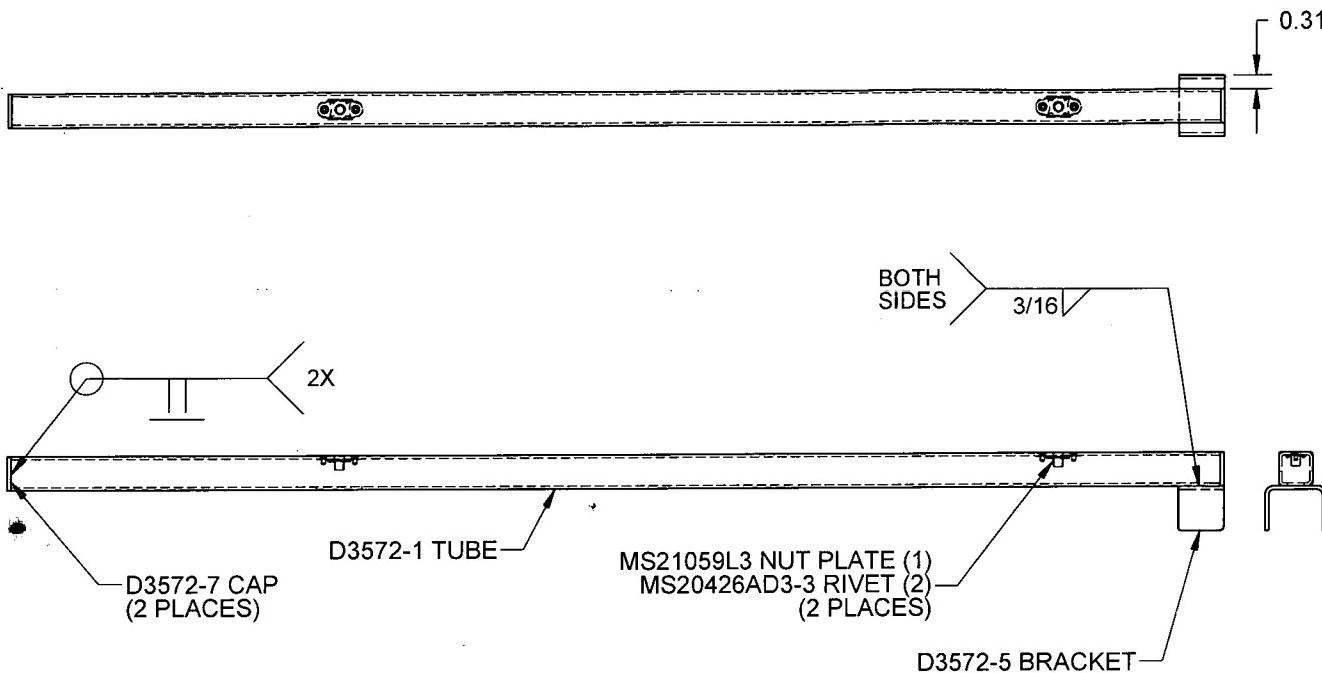
07.03.29

PRELIMINARY ISSUE
NOT FOR FABRICATION

UNDER REVIEW

07.03.21 U

| | | | |
|---------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| B | | D3572 | SHEET 1 OF 2 |
| DATE | 07.03.15 | TITLE | SCALE |
| | | GUIDE ASSEMBLY | 1:4 |
| REV | DATE | DESCRIPTION | |
| A | 07.03.15 | NEW ISSUE | |



D3572-041 GUIDE ASSEMBLY

D3572-041 PARTS LIST:

| QTY | P/N | DESCRIPTION |
|-----|--------------|-------------|
| X | D3572-041 | GUIDE |
| 1 | D3572-1 | TUBE |
| 1 | D3572-5 | BRACKET |
| 2 | D3572-7 | CAP |
| 2 | MS21059L3 | NUT PLATE |
| 4 | MS20426AD3-3 | RIVET |

D3572-041 NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELD PER DART QSI 004
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED